

Work Order ID 75466

Monday, October 24, 2011 9:45:57 AM

75466*Eagly*

Page 1

Item ID: D4458-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel

Start Date: 10/24/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/26/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *11-10-24*

Tooling:

Date:

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4458	A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *A*Prog Rev: *A**6561-125*

2- Deburr if necessary

B11-10-25

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B11-10-25**(3) P10 →*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 744581 PAR #: N/A Fault Category: Small Parts NCR: Yes No DQA: 11/10/28 Date: 11/10/28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/10/31 Date: 11/10/31

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/26	100	Qty x1 Scrap. tip broke fl water at. R.C. Press / machi m/fault.	S 11/10/26 057042	-Scrap + Doty no Rep. extras made.	S 11-10-28	S 11/10/26	S 057042 11/10/26	S 11/10/26

NOTE: Date & initial all entries

Work Order ID 75466***75466***

Page 2

Monday, October 24, 2011 9:45:57 AM

Item ID: D4458-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Panel
Start Date: 10/24/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 10/26/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <i>ASG-02</i>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

11/10/26 *(2)*

11/10/26 *MF*

11-10-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 24, 2011 9:45:56 AM

Page 1

Work Order ID: 75466

Parent Item: D4458-1

Start Date: 10/24/2011

Required Date: 10/26/2011

Parent Item Name: Panel

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.10.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	88.1100	2.3195	4.8831579	71		

Location

Loc Qty

Loc Code

MAT021

88.11

113608

73.17

118217

14.94

113609

(3)

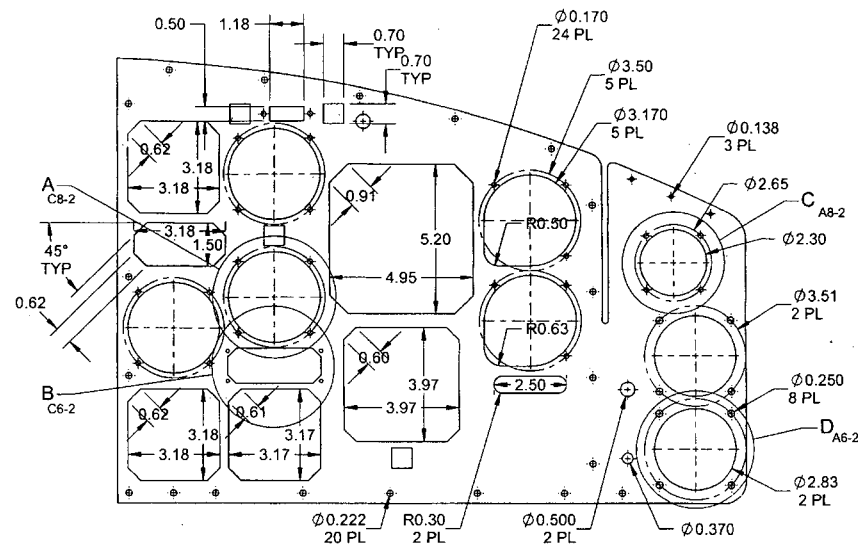
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
R 2011-10-20

D4458-1 PANEL

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR ASM 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
OR
2024-T3 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

A NEW ISSUE		BY DATE	
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	RMF/		
MFG. APPR.			
APPROVED	N/A		
DE APPR.	N/A		
DATE	11.10.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4458

REV. A
SHEET 1 OF 4

TITLE
PANEL (HELI-CORP)

SCALE
NTS

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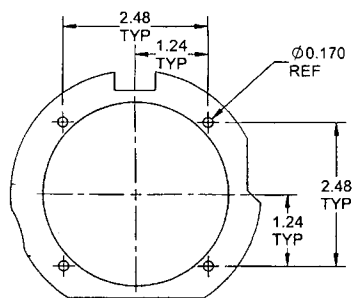
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

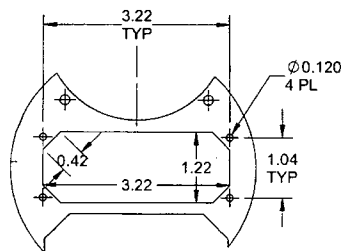
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

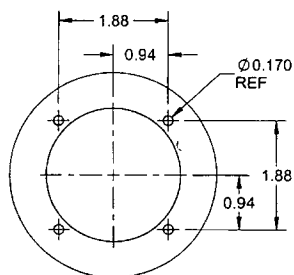
NOTE: Date & initial all entries



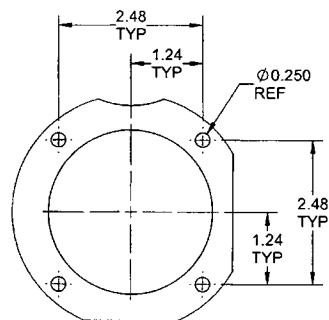
DETAIL A
SCALE 0.5X C4-1



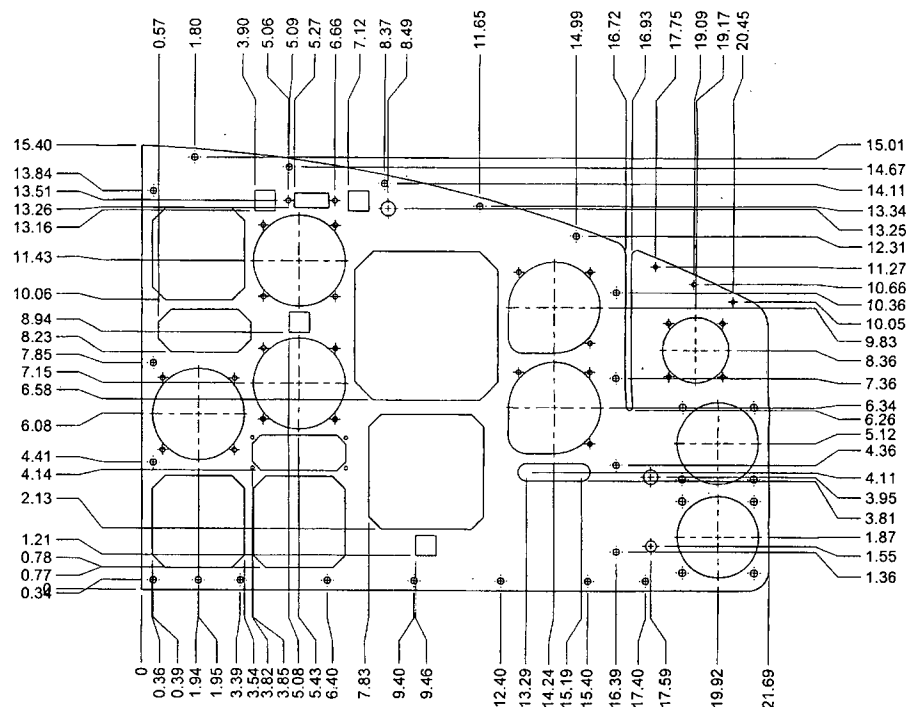
DETAIL B
SCALE 0.5X C4-1



DETAIL C
SCALE 0.5X C2-1



DETAIL D
SCALE 0.5X B2-1



D4458-1 PANEL
AUX VIEW

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2011-10-20

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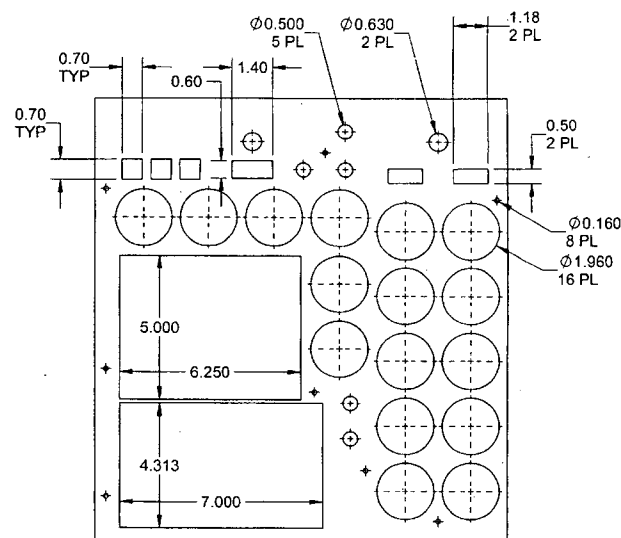
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4458-3 PANEL

RELEASED
2011-10-20

NOTES:

- 1) MATERIAL: CLEAR LEXAN, 0.125 THICK
REF DART SPEC MLEXS.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

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MFG. APPR.		D4458	SHEET 3 OF 4
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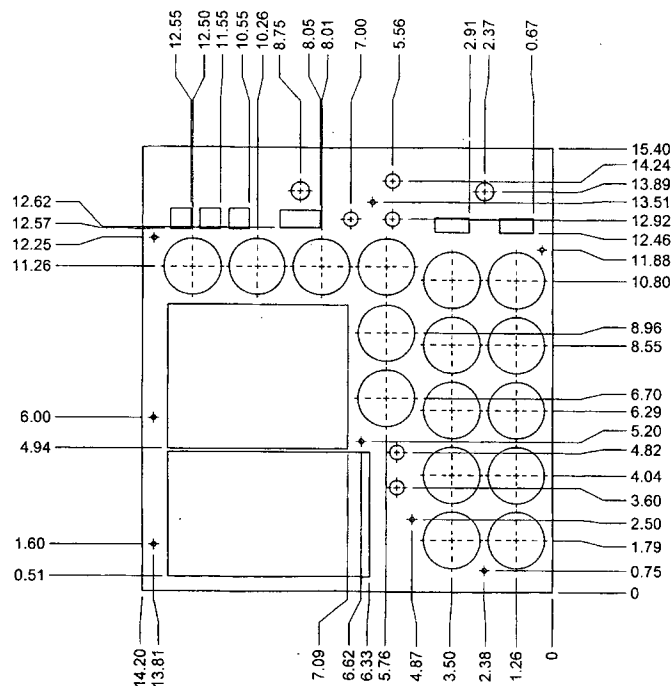
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D4458-3 PANEL
AUX VIEW

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2011-10-20

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CHECKED	FE	DRAWING NO.	REV. A
MFG. APPR.	FE	D4458	SHEET 4 OF 4
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